

CONTROLLED ATMOSPHERE FURNACE AND HEATING METHOD THEREOF

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ABSTRACT OF THE DISCLOSURE

10 In the inventive controlled atmosphere furnace, an
article 11 conveyed through a preheating chamber 1 prior
to being brazed is quickly heated with combustion gas
circulating in a closed-loop flow path through the
preheating chamber to approximately 450°C within the
approximately five minutes determined in view of the
deterioration degree of flux in the atmosphere and the
15 growth of an oxide layer on the article. A gas burner 71
and a circulation fan 6 are provided in the closed-loop
flow path, and the combustion rate of the gas burner and
the circulation rate of the combustion gas due to the
circulation fan are controlled based on the chamber
20 temperature detected by a temperature sensor 9 in the
preheating chamber.